

Date: Monday, 12/03/2007 11:08:06 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31164	
Estimate Number : 12788	
P.O. Number : N/A	Part Number : D356413
This Issue : 12/03/2007 S.O. No. : N/A	Drawing Number : D3564 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>EL</u>	Due Date : 19/03/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-03-08 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1785 sf(s)/Unit Total : 0.1785 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: ml 07 03 12 ①

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: A

Prog Rev: A ml 07 03 12 ①

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 03 12 ①

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK ml 07/03/13 ①

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT and DT ml 07/03/22 ①

ml 07/03/23 ①

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Drawing Name: WEARSHOE

Job Number: 31164

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



N/A
Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

FOR ENGINEERING USE ONLY

FOR ENGINEERING USE ONLY

ig 0703.26

10.0

QC21

FINAL INSPECTION/W/O RELEASE



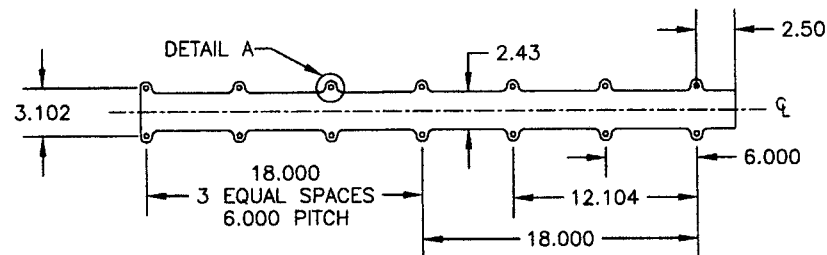
Comment: FINAL INSPECTION/W/O RELEASE

0703/27
00082

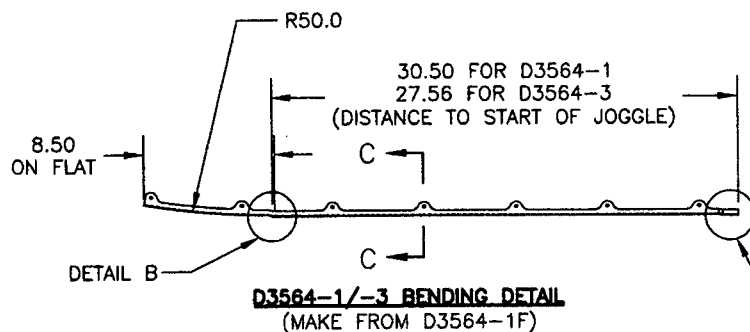
Job Completion



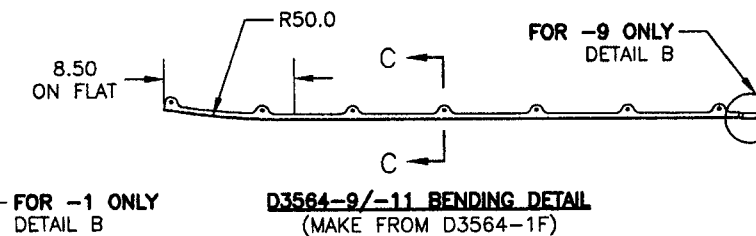
0703-27



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07.07.28

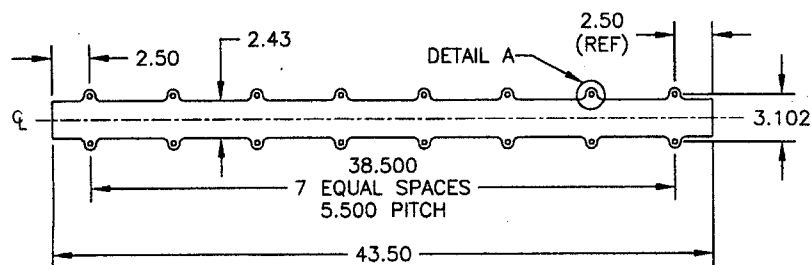
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

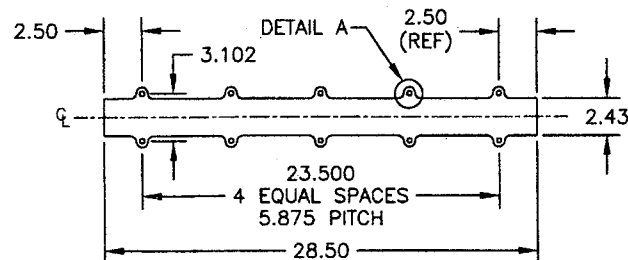
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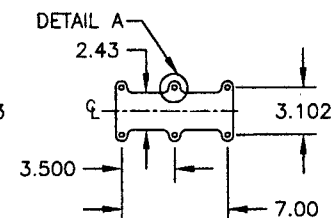
A	06.12.18	NEW ISSUE
DESIGN RH	DRAWN BY RH	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3564
DATE 06.12.18	TITLE WEARSHOE	REV. A SHEET 1 OF 2 SCALE 1:8



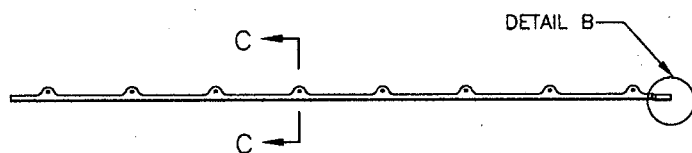
D3564-5F FLAT PATTERN



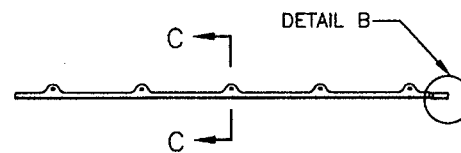
D3564-7F FLAT PATTERN



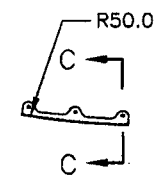
D3564-13F FLAT PATTERN



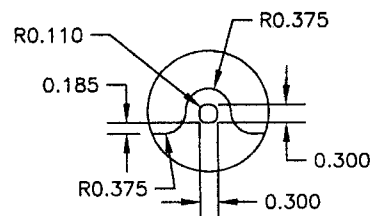
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



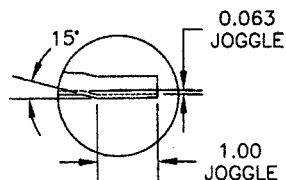
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



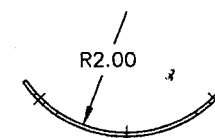
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07-12-78

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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3564	REV. A
DATE 06.12.18	TITLE WEARSHOE	SHEET 2 OF 2	SCALE 1:8

